

Work Order ID 93357

\*93357\*

Page 1

November-19-12 8:58:39 AM

Item ID: D3245-042

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Access Panel Assembly

Start Date: 11/15/12 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: M15

Date: 12-11-12 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	7X	BB/10/10
D3245	D				
100	Pick Kit		0.00		
*100*					
Packaging					
Packaging					
110	Small Fab		0.00	4X	Eb/10/10
*110*					
Small Fab					
Small Fab					
		Install Nut Plates and D3245-5 angle as per Dwg D3245, follow instructions of note 8 on dwg when riveting angle, be careful when countersinking...mat'l very thin			
120	QC5- Inspect part completeness to step on W/O		0.00	4	
*120*					
QC					
Quality Control					

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspector Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							

**Work Order ID** 93357**\*93357\***

Page 2

November-19-12 8:58:39 AM

**Item ID:** D3245-042

Accept

**\*N900040100\***

Setup

Start

**\*NS1\*****Revision ID:**

Stop

**\*NS2\*****Item Name:** Access Panel Assembly**Start Date:** 11/15/12    **Start Qty:** 4.00**\*4\*****Cust Item ID:****Required Date:** 12/07/12    **Req'd Qty:** 4.00**\*4\*****Customer:****Reference:****Approvals:** **Process Plan:** \_\_\_\_\_**Date:** \_\_\_\_\_**Tooling:** \_\_\_\_\_**Date:** \_\_\_\_\_

Run

Start

**\*NR1\*****QC:** \_\_\_\_\_**Date:** \_\_\_\_\_**SPC (Y/N):** \_\_\_\_\_**Date:** \_\_\_\_\_

Stop

**\*NR2\***

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
130 <b>*130*</b> Packaging	Identify as per dwg & Stock Location:  Memo	0.00							<i>13/1/20 04</i>
140 <b>*140*</b> QC	QC21- Final Inspection - Work Order Release  Memo	0.00							<i>13/1/31 00</i>
									<i>MF (3) 1-20</i>

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Picklist Print

November-19-12 8:58:38 AM

Page 1  
16

Work Order ID: 93357

Parent Item: D3245-042

Start Date: 11/15/12

Required Date: 12/07/12

Parent Item Name: Access Panel Assembly

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245-2 Panel		Manufactured	No			110	Each	0.0000	B93292 4X	1	4	EP 13/01/07	
D3245-5 Door		Manufactured	No			110	Each	15.0000		1	4	EP 13/01/07	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			15						
					83468		15						
2350-18-C3Y RIGID RECEPTACLE		Purchased	No			110	Each	119.0000		8	32	EP 13/01/30	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST396			50						
				122819-			50						
				ST399			3						
				121499			3						
				ST400			66						
				105729			2						
				122499			44						
				19688			20						
MS20427M3-3 Rivet		Purchased	No			110	Each	1,899.0000		16	64	EP 13/01/07	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			1744						
				123352			1744						
				ST335			155						
				120930			3						
				121114			140						
				123021			12						

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____  NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Other	

# Picklist Print

Page 2

November-19-12 8:58:38 AM

**Work Order ID:** 93357

**Parent Item:** D3245-042

**Parent Item Name:** Access Panel Assembly

**Start Date:** 11/15/12

**Required Date:** 12/07/12

**Start Qty:** 4.00

**Required Qty:** 4.00

MS20615M3-3

Purchased

No

110

Each

1,151.0000

9

36

Rivet

*JP 13/01/07*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST323	1151	
111650	10	
116188	12	
118384	1129	36

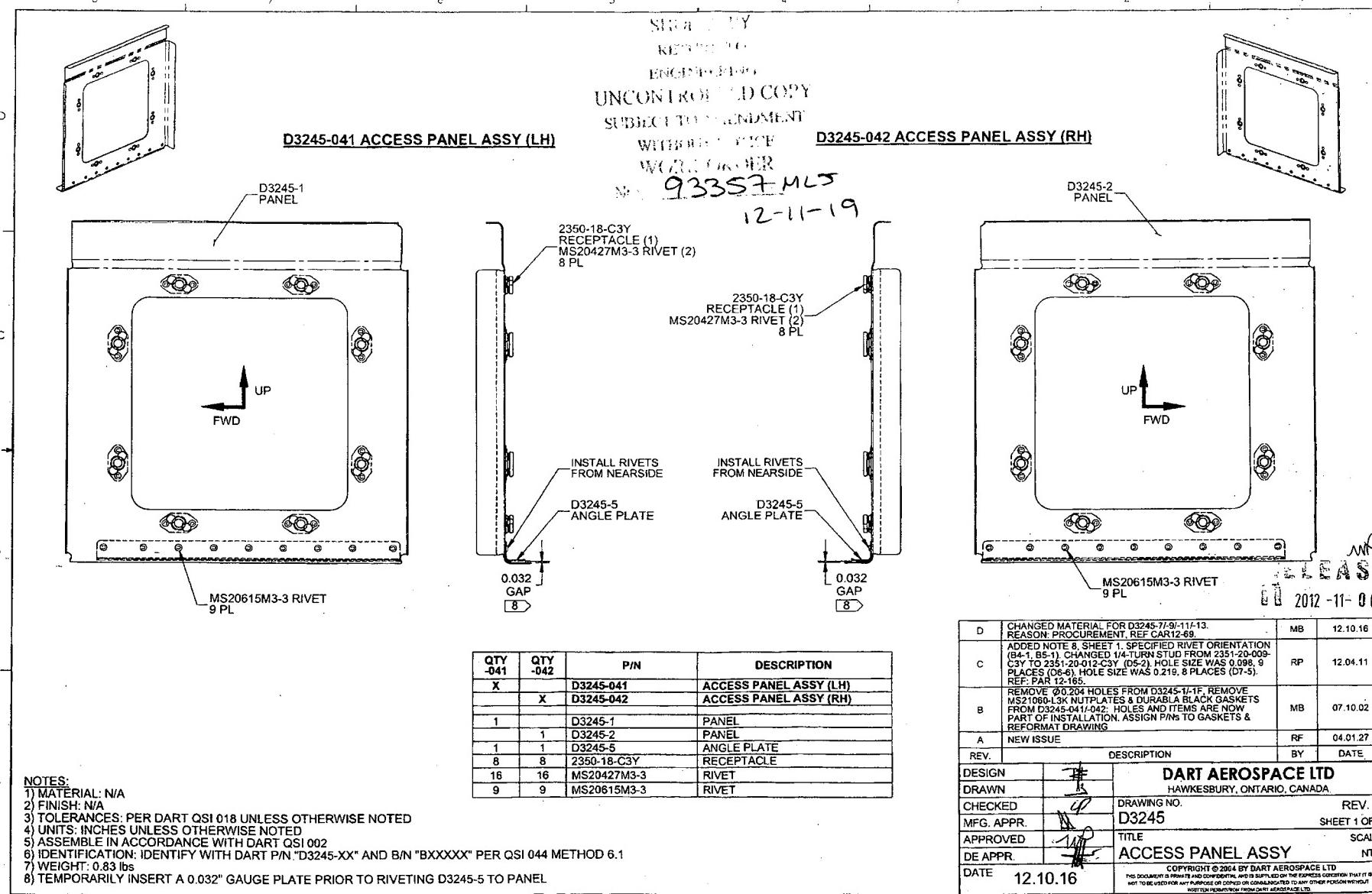
DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

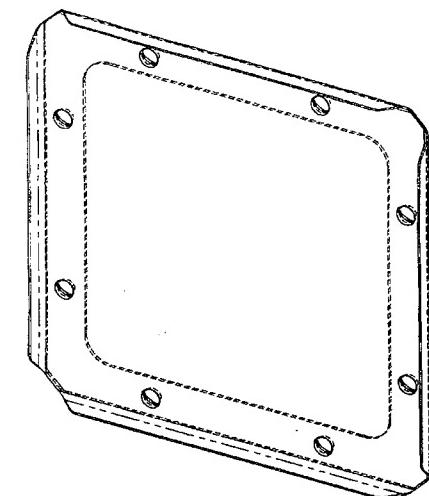
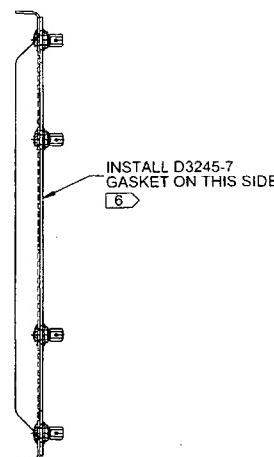
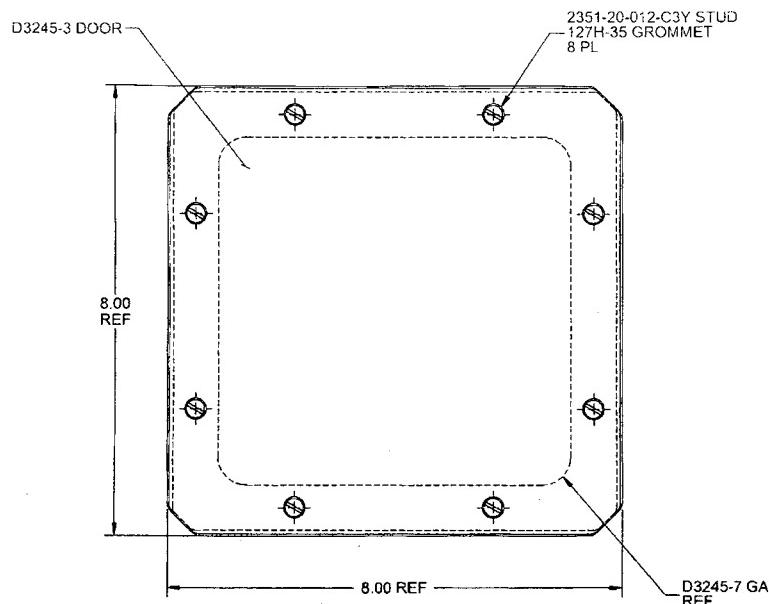
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____  NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio  <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Other	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled



D	CHANGED MATERIAL FOR D3245-7/9-11-13. REASON: PROCUREMENT, REF CART12-69.	MB	12.10.16
C	ADDED NOTE 8, SHEET 1, SPECIFIED RIVET ORIENTATION C3Y TO C3Y & REVERSED RIVET ORIENTATION FROM 2351-20-009- C3Y TO 2351-20-012-C3Y. (05-2) HOLE SIZE WAS 0.098, 9 PLACES (06-6) HOLE SIZE WAS 0.219, 8 PLACES (07-5) REF: PAR 12-165.	RP	12.04.11
B	REMOVE Ø.204 HOLES FROM D3245-1/1F, REMOVE MS21060-13K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW FOR OFF INSTALLATION. ASSIGN P/N'S TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>    </u>	DART AEROSPACE LTD	
DRAWN	<u>    </u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>    </u>	DRAWING NO.	REV. D
MFG. APPR.	<u>    </u>	D3245	SHEET 1 OF 7
APPROVED	<u>    </u>	TITLE	SCALE
DE APPR.	<u>    </u>	ACCESS PANEL ASSY	NTS
DATE	12.10.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

93357



### D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

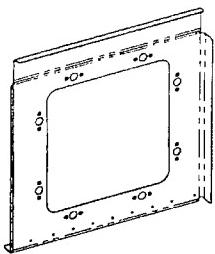
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.74 lbs

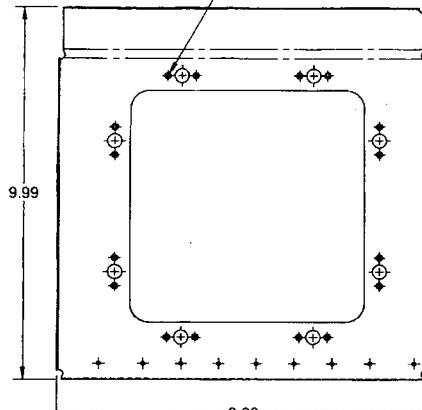
RELEASED  
2012-11-06  
N/A

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DRAWN	<u>10</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>10</u>	DRAWING NO. REV. D
MFG. APPR.	<u>10</u>	D3245 SHEET 2 OF 7
APPROVED	<u>10</u>	TITLE SCALE
DE APPR.	<u>10</u>	ACCESS PANEL ASSY NTS
DATE	12.10.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

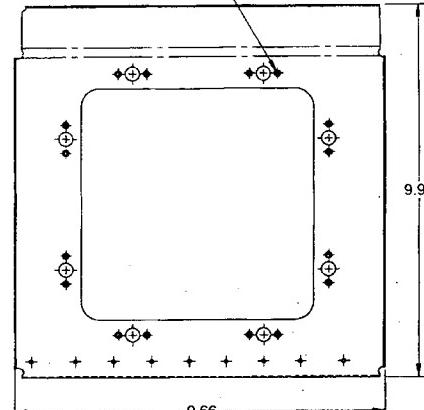
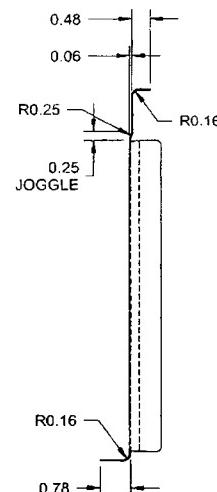
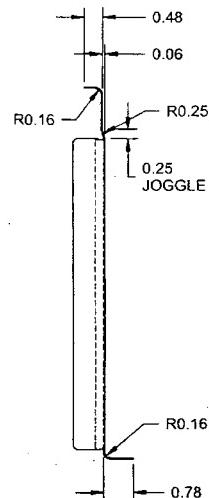
93357



$\phi$ 0.098 THRU  
CSK  $\phi$ 0.170 X 100°  
25 PL



D3245-1 PANEL (LH)



D3245-2 PANEL (RH)

RELEASED  
2012-11-06  
JW

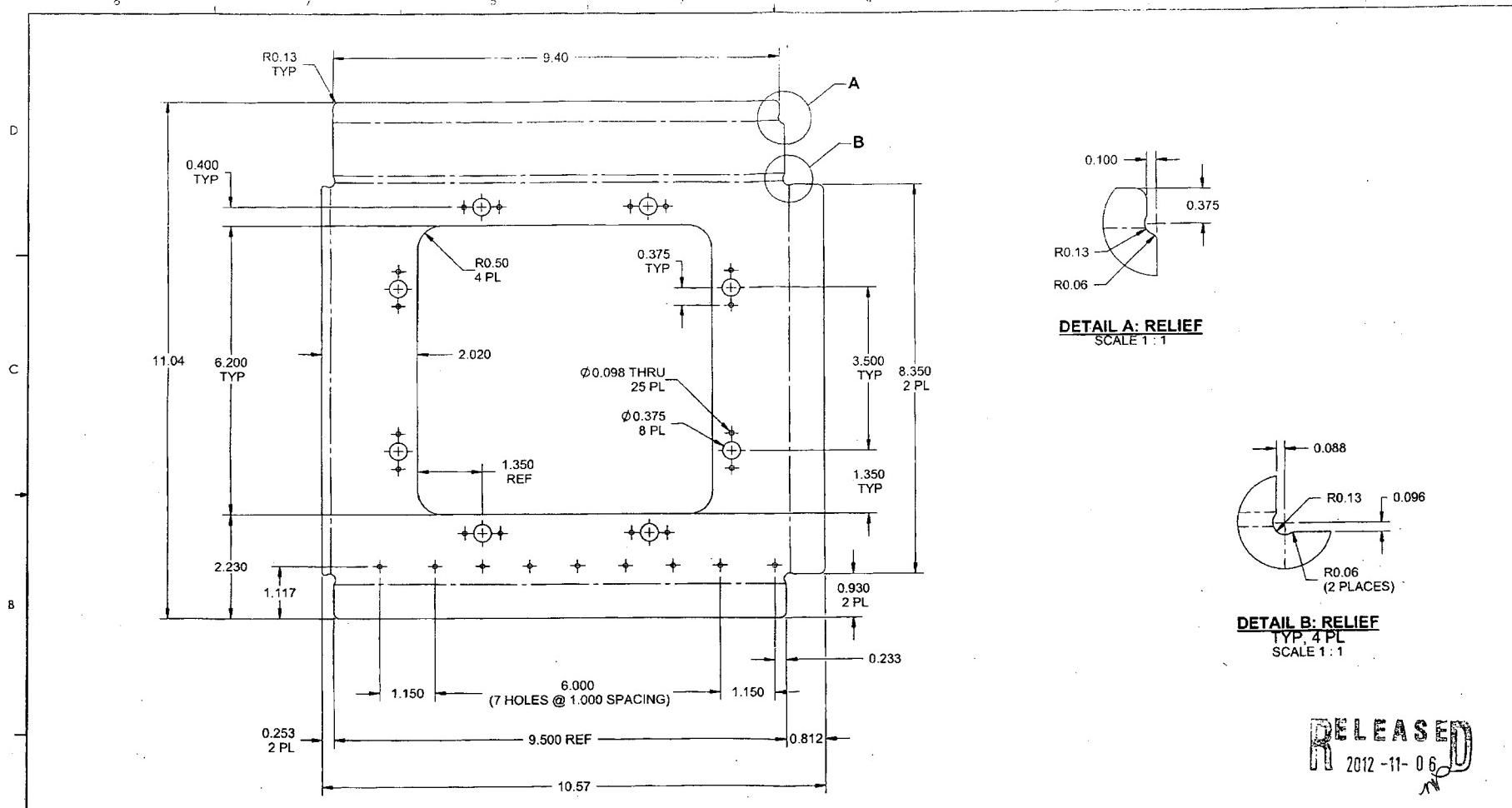
- NOTES:  
 1) MATERIAL: MAKE FROM D3245-1F  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.70 lbs

DESIGN	<u>1</u>	DART AEROSPACE LTD
DRAWN	<u>1</u>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<u>1</u>	DRAWING NO.
MFG. APPR.	<u>1</u>	REV. D
APPROVED	<u>1</u>	D3245
DE APPR.	<u>1</u>	SHEET 3 OF 7
DATE	12.10.16	TITLE
		SCALE
		NTS
		ACCESS PANEL ASSY

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8 7 6 5 4 3 2 1

93357

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

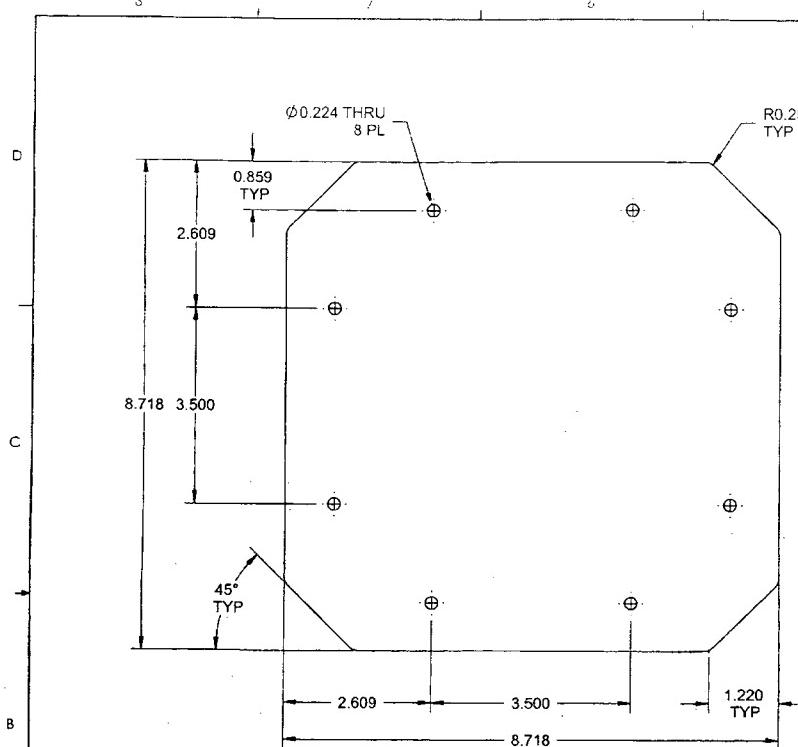
**D3245-1F PANEL FLAT PATTERN**

DESIGN	<i>EF</i>	DART AEROSPACE LTD	
DRAWN	<i>EP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>EP</i>	DRAWING NO. D3245	
MFG. APPR.	<i>EP</i>	REV. D	
APPROVED	<i>JW</i>	SHEET 4 OF 7	
DE APPR.	<i>JW</i>	TITLE ACCESS PANEL ASSY	
DATE	12.10.16	SCALE NTS	

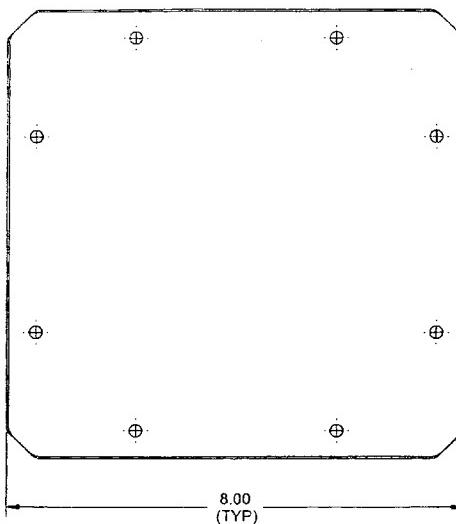
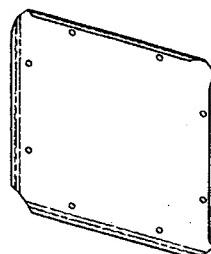
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RELEASED  
2012-11-06

93357



D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR  
(MADE FROM D3245-3F)

## NOTES:

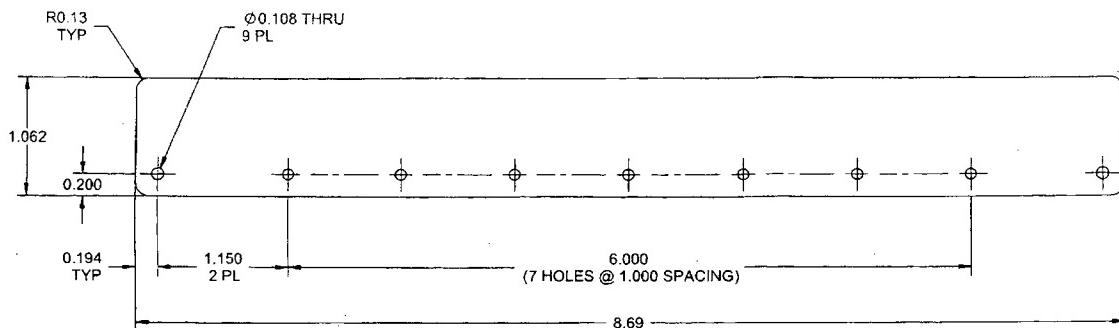
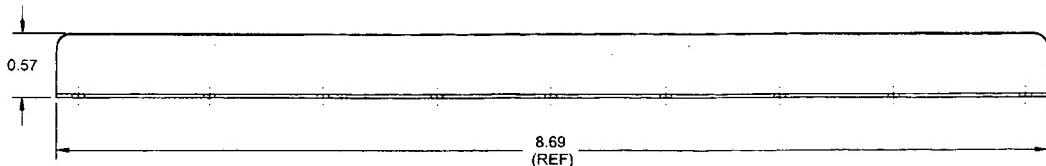
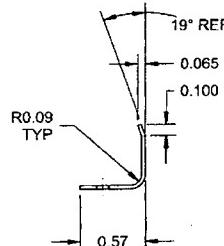
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs

DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.
MFG. APPR.	<input checked="" type="checkbox"/>	REV. D
APPROVED	<input checked="" type="checkbox"/>	D3245
DE APPR.	<input checked="" type="checkbox"/>	TITLE
DATE	12.10.16	SCALE
		NTS

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RELEASED  
2012-11-06 [initials]

93357

**D3245-5 FLAT PATTERN****D3245-5 ANGLE PLATE**  
(MAKE FROM D3245-5F)

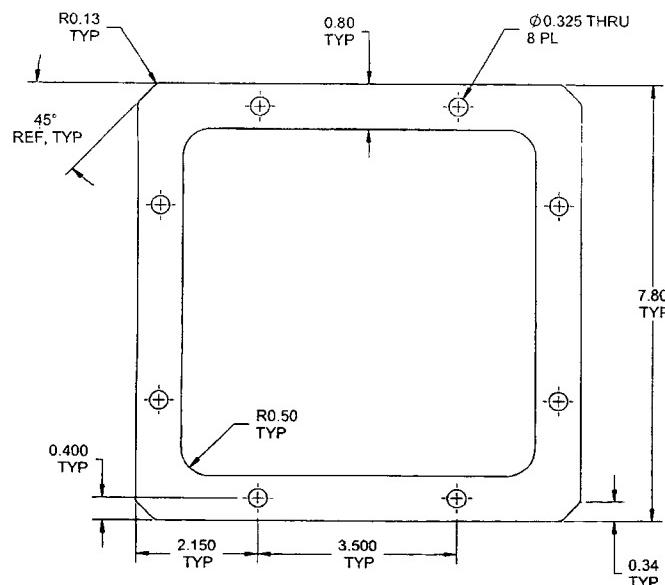
RELEASE  
2012-11-06  
JW

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	7F	DART AEROSPACE LTD
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA
CHECKED	UP	DRAWING NO. REV. D
MFG. APPR.	JW	D3245 SHEET 6 OF 7
APPROVED	JW	TITLE SCALE
DE APPR.	JW	ACCESS PANEL ASSY NTS
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93357

D3245-7 GASKETD3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

- NOTES:
- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. D
MFG. APPR.		D3245 SHEET 7 OF 7
APPROVED		TITLE SCALE
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2012-11-06